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D412-698-023
Job Sheet 181275



Part No: D412-698-023

Job Qty: 4 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/6/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	4 Ea		8/6/18	0.00	0.00	Start Up Stores/Pkg-2			JUL 31 2018
110	Packaging	4 pcs		8/6/18	0.00	0.00	Packaging1-4			JUL 31 2018
120	QC	4 pcs		8/6/18	0.00	0.00	QC4			AUG 07 2018
130	Packaging	4 pcs		8/6/18	0.00	0.00	Packaging3-2			JRB
135	DC	4 pcs		8/6/18	0.00	0.00	DC			JRB
140	QC21-FG	4 Ea		8/6/18	0.00	0.00	QC21			

Part Op Descriptions: 135 - Photocopy bluefile & type labels per PPP D412-698-023 CHG003

DAS
21
9-86
AUG 08 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop	4 Ea (1 ea)	90-Start up Operation	5082370
D3594-043	Floor Doubler Assembly, LH	4 Ea (1 ea)	90-Start up Operation	5081372
D3594-044	Floor Doubler Assembly, RH	4 Ea (1 ea)	90-Start up Operation	5081374
D3594-5	Doubler	4 Ea (1 ea)	90-Start up Operation	5081368
D3622-1	Ball Stud	8 Ea (2 ea)	90-Start up Operation	5081667
MS20426AD4-4	Rivet	8 Ea (2 ea)	90-Start up Operation	FM13 2536
MS21073L5	Anchor Nut	4 Ea (1 ea)	90-Start up Operation	5083550
NAS1149D0516J	Washer	8 Ea (2 ea)	90-Start up Operation	5007015

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-11	4	8	0
	D3594-043	4	11	0
	D3594-044	4	5	0
	D3594-5	4	8	0
	D3622-1	8	15	0
	MS20426AD4-4	8	590	0
	MS21073L5	4	30	0
	NAS1149D0516J	8	128	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	

Root Cause		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wav ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : ☐

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DART AEROSPACE
 Container No: S097836
 Part: D412-698-023
 Job No: 181275
 Serial No/Batch: S097836
 Revision: G
 Inspector:
 Exp Date:
 Instructions: TC STC SH92-43 Issue 5, FAA-67C SR01446NY 08/02/08, EASA S

Instructions Incomplete/unclear ☐
 Drill Holes ☐

Misaligned/on center ☐

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

REFERENCE ONLY